

Work Order ID 149576

Monday, July 25, 2016 2:37:02 PM

149576

Page 1

Item ID: D3884-2

Revision ID:

Item Name: Saddle, Inboard RH

Start Date: 7/29/2016 Start Qty: 6.00

Required Date: 8/5/2016 Req'd Qty: 6.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan:

DAS
21
9-89

Date: AUG 02 2016

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3884	C								

100

0.03

100

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Program Batch No. 149 576
Double check by: JFC1-Machine Step No 1 per Folio FA819 and inspect per attached Dimension
Sheets
2-Machine Step No 2 per Folio FA819 and inspect per attached Dimension
Sheets
3-Machine Step No 3 per Folio FA819 and inspect per Dimension Sheets

0.95

10

φ

J16-09-04

110

0.00

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.01

10

φ

J16-09-04

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER :							

Work Order ID 149576

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Page 2

Item ID: D3884-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Inboard RH

Start Date: 7/29/2016 Start Qty: 6.00 ***6***

Cust Item ID:

Required Date: 8/5/2016 Req'd Qty: 6.00 ***6***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC8- Inspect parts - second check 0.00

120

QC

Memo

Quality Control

0.02

b. 16/09/07

10

0

DAS
08
9-39

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

Hand Finishing

0.12

(X1024) 0

2016/09/07
BEB

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Work Order ID 149576

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Page 3

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Revision ID: Stop ***NS2***
Item Name: Saddle, Inboard RH
Start Date: 7/29/2016 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 8/5/2016 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
140									
Powdercoat									
Powder Coating									
	Memo	0.03							
	MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT AS PER INDICATED ON DWG (SEE NOTE 2)								
	<i>in 135418</i>								
	DO NOT MASK INSIDE FLANGE SURFACE								
	START TIME: <i>2:45</i>								
	OVEN TEMPERATURE: <i>320°</i>								
	FINISH TIME: <i>3:15</i>								
150	QC3- Inspect Part Finish	0.00							
150									
QC									
Quality Control	Memo	0.01							

10 *16-09-8* *34* *9-89*

10 *38* *9-89*

SEP 09 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Work Order ID 149576

Monday, July 25, 2016 2:37:02 PM

149576

Page 4

Item ID: D3884-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Inboard RH

Start Date: 7/29/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 8/5/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>SK101</u>	0.00							
160									
Packaging	Memo	0.01							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.10							
Quality Control									

DAS
6
9-89

SEP 09 2016

DAS
21
9-89

SEP 09 2016

DAS
21
9-89

SEP 09 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

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Page 1

Work Order ID: 149576

149576

Parent Item: D3884-2

D3884-2

Parent Item Name: Saddle, Inboard RH

Start Date: 7/29/2016

Required Date: 8/5/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC
15.05.20 remove inside powdercoat DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-017		Manufactured	No				Each	51.0000		6			
D6101-017									**				
Saddle Billet													

DAS
44
9-89

16-09-02

Location

Loc Qty

Loc Code

MAT046

51

142580

1

144956

50

6

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

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								QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
OTHER : _____																																																															

DART AEROSPACE LTD		Work Order: 149576
Description: Saddle, Inboard, RH		Part Number: D3884-2
Inspection Dwg: D3884	Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	2.870	2.880		2.875	2.875	2.875	2.875		2.875
B	1.433	1.443		1.438	1.438	1.438	1.438		1.438
C	0.638	0.658	519	.647	.648	.648	.648		.648
D	3.895	3.905		3.900	3.900	3.900	3.900		3.900
E	0.257	0.262		.258	.258	.258	.258		.258
F	0.605	0.625	486	.614	.615	.615	.615		.615
G	1.120	1.130		1.125	1.125	1.125	1.125		1.125
H	2.245	2.255		2.250	2.250	2.250	2.250		2.250
I	2.000	2.020		2.000	2.000	2.000	2.000		2.000
J	0.140	0.175		.151	.151	.151	.151		.151
K	1.265	1.285		1.265	1.265	1.265	1.265		1.265
L	0.115	0.135		.126	.126	.126	.125		.126
M	0.240	0.260		.251	.251	.251	.250		.251
N	0.110	0.140		.135	.135	.135	.135		.135
O	0.240	0.260		.253	.251	.251	.252		.251
P	2.826	2.886		2.855	2.855	2.855	2.855		2.855
Q	0.178	0.198		.189	.188	.188	.188		.188
R	0.140	0.165		.153	.152	.154	.154		.153
S	0.720	0.780		.760	.760	.760	.760		.760
T	1.220	1.280		1.255	1.252	1.250	1.250		1.250
U	1.245	1.255		1.250	1.250	1.250	1.250		1.250
V	5.990	6.010		6.000	6.000	6.000	6.000		6.000
W	2.495	2.505		2.500	2.500	2.500	2.500		2.500
X	0.490	0.510	3435	.499	.505	.505	.505		.503
Y	0.020	0.040		.035	.035	.035	.035		.035
Z	0.313	0.318		.313	.313	.313	.313		.313
AA	0.760	0.765		.760	.760	.760	.760		.760
AB	0.215	0.220		.219	.219	.219	.219		.219
AC	0.316	0.321		.316	.316	.316	.316		.316
AD	1.745	1.755		1.750	1.750	1.750	1.750		1.750
AE	0.990	1.010	842	1.000	1.001	1.0005	1.000		1.001
AF									
Accept/Reject									

Measured by:	P16-09-04
Date:	

Audited by:	DAS
Date:	16/09/07

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	15.09.09	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order:	149576
Description: Saddle, Inboard, RH		Part Number:	D3884-2
Inspection Dwg: D3884	Rev. C	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

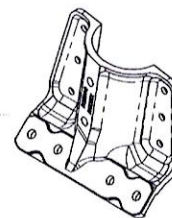
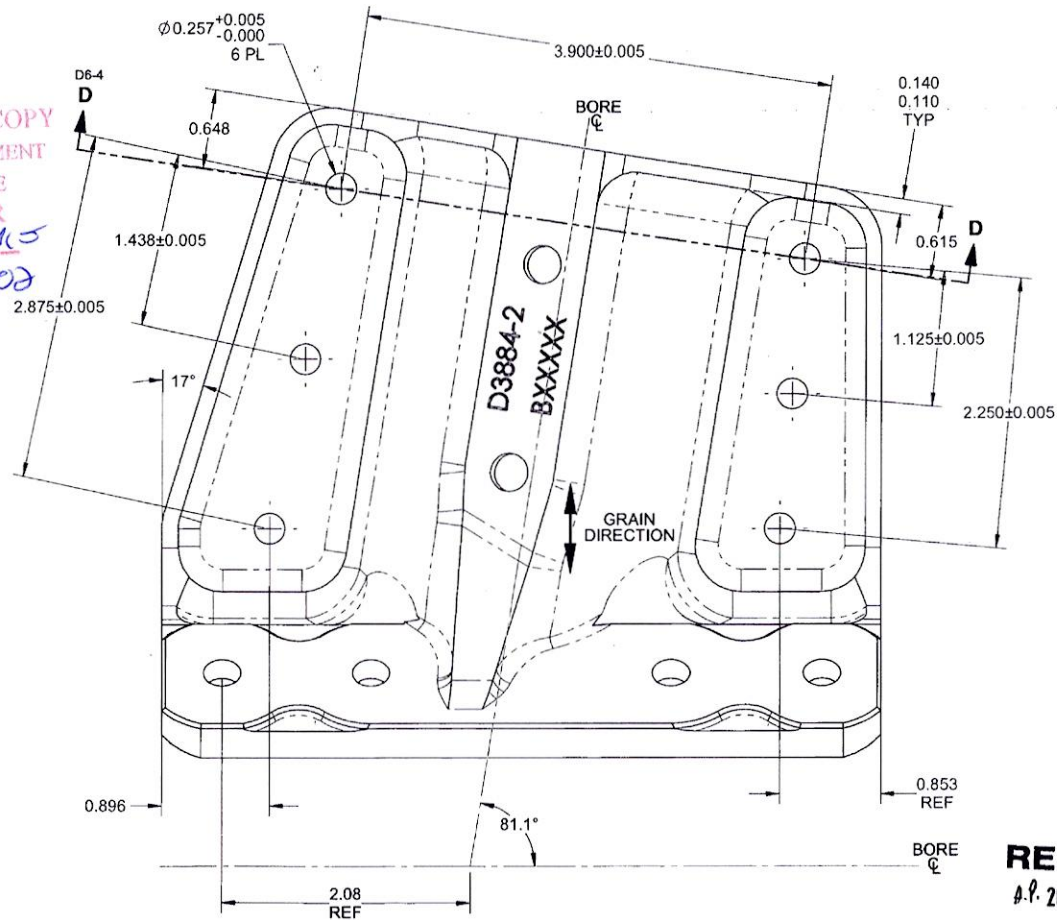
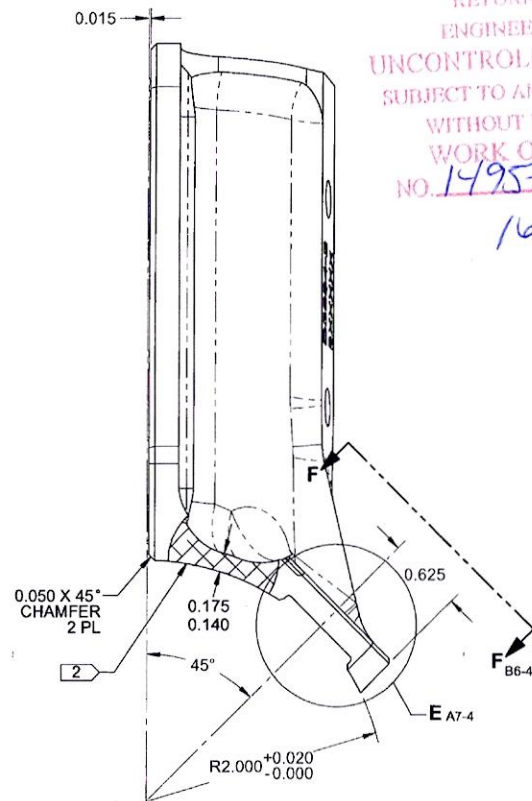
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	6	7	8	9	By	Date
A	2.870	2.880		2.875	2.875	2.875	2.875		2.875
B	1.433	1.443		1.438	1.438	1.438	1.438		1.438
C	0.638	0.658	519	.648	.648	.648	.648		.648
D	3.895	3.905		3.900	3.900	3.900	3.900		3.900
E	0.257	0.262		.258	.258	.258	.258		.258
F	0.605	0.625	486	.615	.615	.616	.616		.616
G	1.120	1.130		1.125	1.125	1.125	1.125		1.125
H	2.245	2.255		2.250	2.250	2.250	2.250		2.250
I	2.000	2.020		2.200	2.200	2.200	2.200		2.200
J	0.140	0.175		.152	.153	.153	.153		.153
K	1.265	1.285		1.265	1.265	1.265	1.265		1.265
L	0.115	0.135		.125	.125	.125	.126		.126
M	0.240	0.260		.250	.250	.250	.251		.251
N	0.110	0.140		.135	.135	.135	.135		.135
O	0.240	0.260		.251	.251	.251	.251		.251
P	2.826	2.886		2.855	2.858	2.855	2.855		2.855
Q	0.178	0.198		.188	.188	.188	.188		.188
R	0.140	0.165		.153	.154	.154	.153		.154
S	0.720	0.780		.760	.760	.760	.760		.760
T	1.220	1.280		1.250	1.252	1.250	1.250		1.250
U	1.245	1.255		1.250	1.250	1.250	1.250		1.250
V	5.990	6.010		6.000	6.000	6.000	6.000		6.000
W	2.495	2.505		2.500	2.500	2.500	2.500		2.500
X	0.490	0.510	3435	.500	.501	.500	.501		.501
Y	0.020	0.040		.035	.035	.035	.035		.035
Z	0.313	0.318		.313	.313	.313	.313		.313
AA	0.760	0.765		.760	.760	.760	.760		.760
AB	0.215	0.220		.219	.219	.219	.219		.219
AC	0.316	0.321		.316	.316	.316	.316		.316
AD	1.745	1.755		1.750	1.750	1.750	1.750		1.750
AE	0.990	1.010	842	1.001	1.001	1.003	1.003		1.003
AF									
Accept/Reject									

Measured by:	JIC-07-04
Date:	

Audited by:	DAS
Date:	16/09/09

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	15.09.09	Dwg Rev updated	KJ	

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NO. 149579 M-5
160803



D3884-2 SADDLE, INBOARD RH

RELEASE
P. 2015 MAY 19

NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO
MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.03 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD R0.250
- 9) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D3884-2-REVC.SLDPRT"

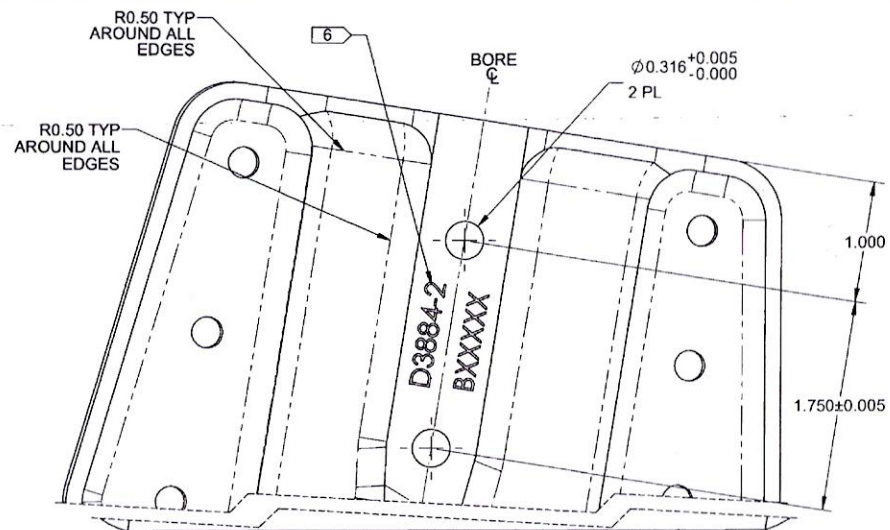
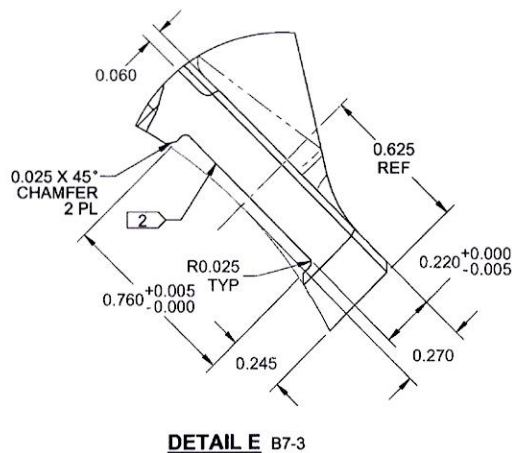
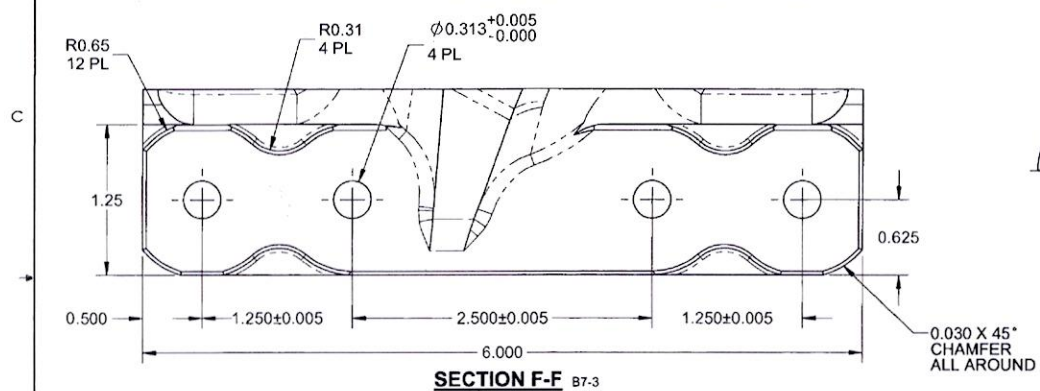
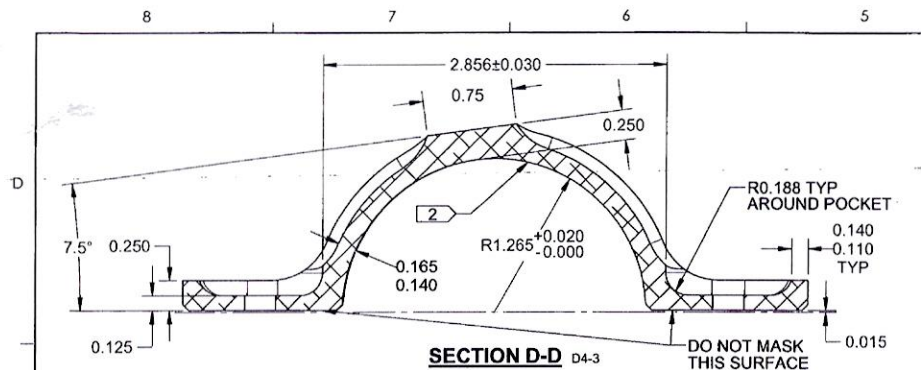
APPROVED

DESIGN	AP
DRAWN	AP
CHECKED	AJS
MFG. APPR.	JLM
APPROVED	HS
DE APPR.	DS
DATE	15.02.11

DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO. D3884	REV. C SHEET 3 OF 4
TITLE INBOARD SADDLE	SCALE NTS

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RELEASED
A.P. 2015 MAY 19

APPROVED	DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
	DRAWN	AP		
	CHECKED	AJS	DRAWING NO.	REV. C
	MFG. APPR.	JLM	D3884	SHEET 4 OF 4
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	INBOARD SADDLE	NTS
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